

628-021 Blue

Dart Aerospace Ltd.

48

Date: Wednesday, 9/26/2007 2:08:33 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	206L /407 STEP ASSY, LH		
Job Number	34891A						
Estimate Number	11702						
P.O. Number	:			Part Number	:	D2724041	
This Issue	9/26/2007	S.O. No.	:	Drawing Number	:	D2724 REV C	
Prsht Rev.	NC			Project Number	:		
First Issue	11	Type	LARGE FAB ASSY	Drawing Revision	:	C	
Previous Run	33756A			Material	:		
Written By	:	11		Due Date	10/30/2007	Qty:	2 Um: Each
Checked & Approved By	:	07.09.26					
Comment	Est Rev E	As Per Ecn 766	06-01-06	JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	334016

Check Material for any Dents or Defects

16 07.09.28 2

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-1 using D2622 extrusion as per Dwg D2724

Deburr and bevel ends for welding

16 07.09.28 2

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

206 Step Endplate;

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	333861 f2B 34485 f2

16 07.10.01 2

4.0 D34581 PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-1	Plate	334179

16 07.10.01 2

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/26/2007 2:08:33 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 206L /407 STEP ASSY, LH
Job Number: 34891A		Part Number: D2724041
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	D34583	PLATE 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Pick: Qty Part Number Description Batch		<i>JK 01-10-01 2</i>
2 D3458-3 Plate <i>334180</i>		
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1		
Weld end cap and lugs as per Dwg D2724 using Jig DT8884 DT (One End Only) A/R AL ROD Batch: <i>M103194</i> <i>M105058</i>		followed by Jig <i>JK 07-10-04 2</i>
Grind end cap welds flush		
7.0	QC9	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION		<i>PD 07-10-09 (2)</i>
8.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		<i>JK 07-10-09 (244)</i>
9.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		<i>JK 07-10-09. 2</i>
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<i>JK 07-10-16 2</i>
11.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1		
Inspect for foreign object per QSI 024		<i>JK 07-10-16 2</i>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/26/2007 2:08:33 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 206L1407 STEP ASSY, LH
Job Number: 34891A		Part Number: D2724041
Job Number:		
Seq. #:	Machine Or Operation:	Description:
	Weld Remaining end cap as per Dwg D2724 using Jig DT DT A/R AL ROD Batch: <u>N103794</u>	followed by Jig <i>date 07-10-16</i>
	Grind per dwg D2724	<i>A.M 07-10-16</i>
12.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION		<i>07-10-17 (2)</i>
13.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		<i>07-10-17 (2)</i>
14.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 <i>(+pressure wash)</i>
Comment: HAND FINISHING RESOURCE #1		<i>07-10-18 (2)</i>
	Touch up Alodine	
15.0	SPRAY PAINTING	SPRAY PAINTING
Comment: Issue P.O <u>N/A</u> Atelier Debosselage		<i>25 07-10-26</i>
	Spray Paint Delfleet Blue Clear with Delfleet	<i>ML 07-10-19 (2)</i>
16.0	QC14	INSPECT SPRAY PAINT
Comment: INSPECT SPRAY PAINT		<i>25 07-10-22</i>
17.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: Wing Walk as per Dwg D2724 and QSI 00 54.4		<i>ML 07-10-28 (2)</i>
18.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<i>10 11-13 (2)</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/26/2007 2:08:33 PM
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Process Sheet

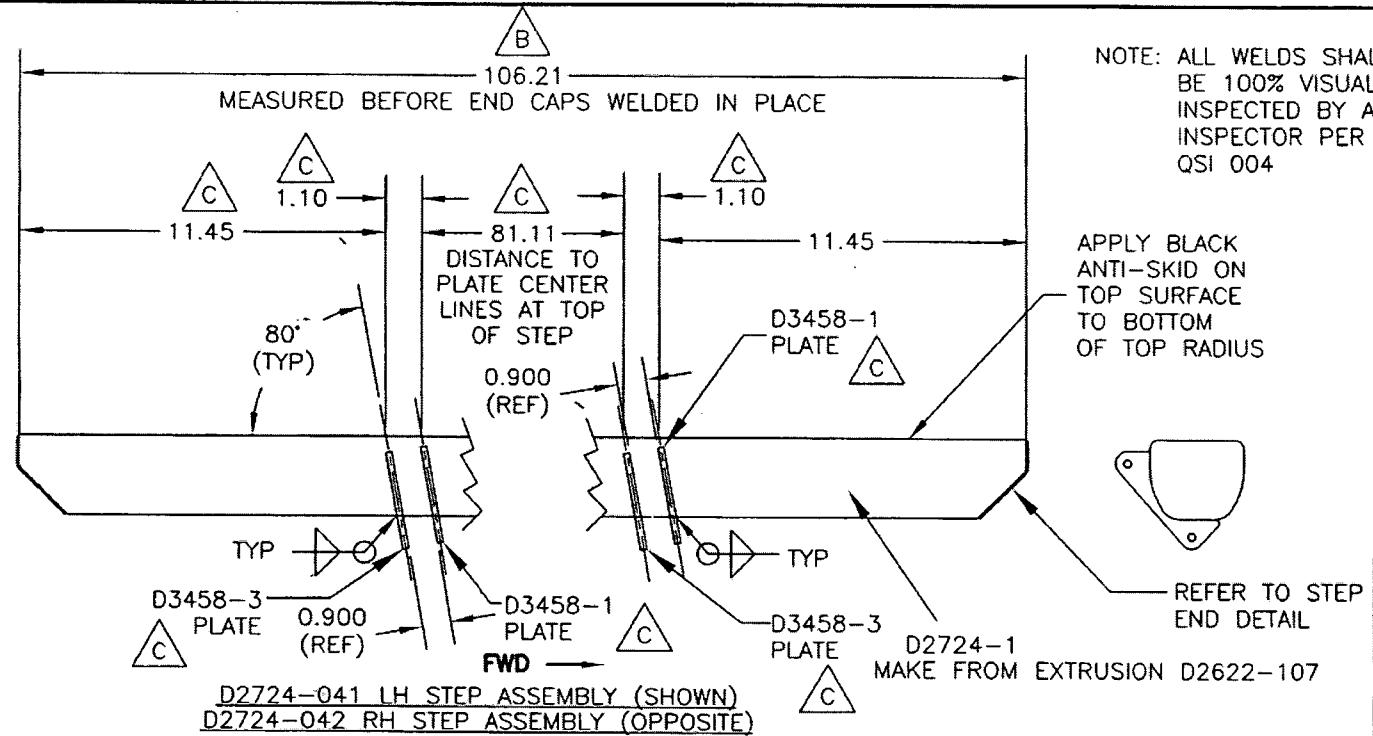
Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 206L /407 STEP ASSY, LH
Job Number: 34891A		Part Number: D2724041
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
19.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>PP 34891 10/10/30 (2)</i>		
20.0	QC21 	FINAL INSPECTION/W/O RELEASE  <i>01.10.31 AF</i>
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		<i>01.10.31</i>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
X		D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

SHOP COPY

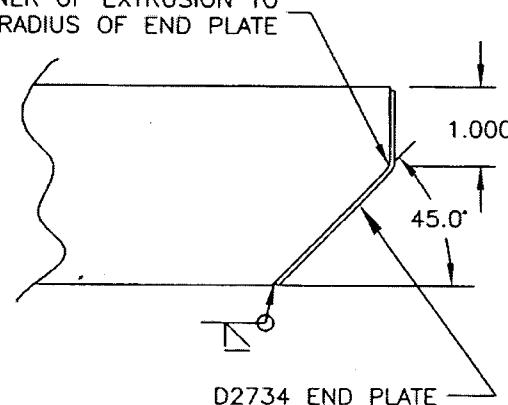
RETURN TO

ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
323529

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED #	APPROVED #	DRAWING NO. D2724
DATE C	DATE B	DATE A
05.09.19	98.10.19	97.12.04
RE-DESIGN, ADD D3458-1/-3	UPDATED WELD DETAIL REV. C REvised TOLERANCES	NEW ISSUE
206L/407 STEP ASSEMBLY	TITLE	TITLE
NTS	SCALE	SCALE
	SHEET 1 OF 1	

DART

RELEASED
05.11.14